

Work Order ID 53818-2

November 18, 2009 4:07:03 PM



Beauregard

Page 1

Item ID: D4015-041

Accept



Setup Start



Revision ID:

Item Name: Wearbar Weldment

106

Stop



Start Date: 11/18/2009 Start Qty: 100.00

Required Date: 11/24/2009 Req'd Qty: 100.00



Cust Item ID:

Customer:

Reference:

Run Start



Approvals: Process Plan: MF

Date: 09-11-19 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D4015	B
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100 Pick Kit 0.00



Packaging Memo 0.00

Packaging

*[Signature]* 09/11/25

110

Weld per dwg A/R Hardcoat S.S. Batch: M112963 0.00



Large Fab Memo M112963 0.00

Large Fab

*[Signature]* 9-11-23 (X21)  
09.11.25 (X151)

120

QC5- Inspect part completeness to step on W/O 0.00



QC Memo 0.00

Quality Control

*[Signature]* 09/11/25

(X51) *[Signature]*



# Work Order ID 53818

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Page 2

Item ID: D4015-041

Accept

Revision ID:

Item Name: Wearbar Weldment

Start Date: 11/18/2009 Start Qty: 100.00

Required Date: 11/24/2009 Req'd Qty: 100.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Setup Start

Stop

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC10- Inspect visual per QSI004- ground welds

0.00

⇒ 8071425

count  
(157) ✓

QC

Memo

0.00

Quality Control

135

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

⇒ 16 09/11/26

(X131) ✓

Powdercoat

Memo

0.00

11109091

POWDER COAT:

Start Time: 4:08am

Oven Temperature: 320°F

Finish Time: 10:30am

136

QC3- Inspect Part Finish

0.00

pk 09-11-26

(151) ✓

QC

Memo

0.00

Quality Control





# Work Order ID 53818

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Page 3

Item ID: D4015-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearbar Weldment

Start Date: 11/18/2009 Start Qty: 100.00



Cust Item ID:

Required Date: 11/24/2009 Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

140

Identify as per dwg & Stock Location: THRU

0.00



Packaging

Memo

*THRU*  
*w/o 53815*

0.00

Packaging

*151* *09/11/26*

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*09/11/26*

*me*  
*09-11-26*



# Picklist Print

November 18, 2009 4:07:03 PM

Page 1

Work Order ID: 53818



Parent Item: D4015-041



Parent Item Name: Wearbar Weldment

Start Date: 11/18/2009

Required Date: 11/24/2009

Comments: IPP RevA: New issue 09.11.03 DD verified by:EC  
remove waterjet 09.11.03 DD verified by:EC  
dwg 09.11.18 DD verified by:JLM

IPP RevB:  
IPP RevC: revC as per

Start Qty: 100.00

Required Qty: 100.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D4015-1		Manufactured	No			100	Each	0.0000	100.0000			



Wearbar

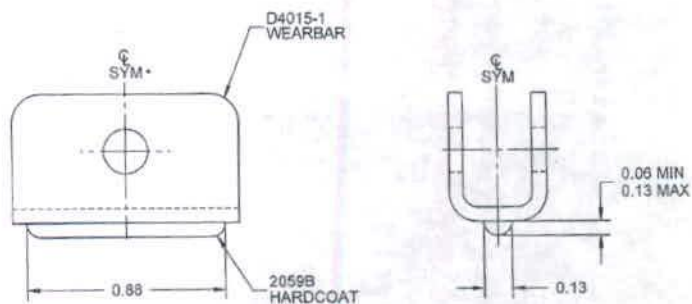


09.11.25  
353819 → (151) ✓

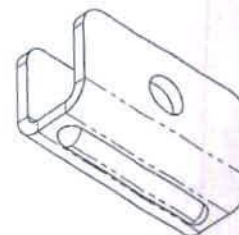




ITEM	QTY	P/N	DESCRIPTION
1	1	D4015-041	WEARBAR WELDMENT
11	1	D4015-1	WEARBAR
21	A/R	2059B	HARDCOAT



**D4015-041 WEARBAR WELDMENT**



**NOTES:**

- 1) MATERIAL: SEE SHEET 2 FOR D4015-1
- 2) FINISH: POWDER COAT "BLACK SANDEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs
- 8) WELDING: PER DART QSI 004

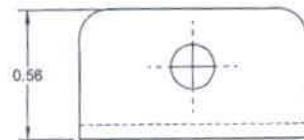
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A	NEW ISSUE	MB	09.10.23
REV	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.11.13		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

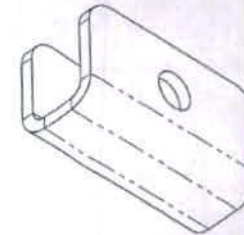
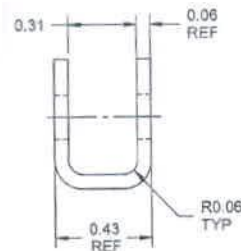
DRAWING NO. REV. B  
**D4015**  
SHEET 1 OF 2  
TITLE  
**WEARBAR WELDMENT**  
SCALE  
NTS

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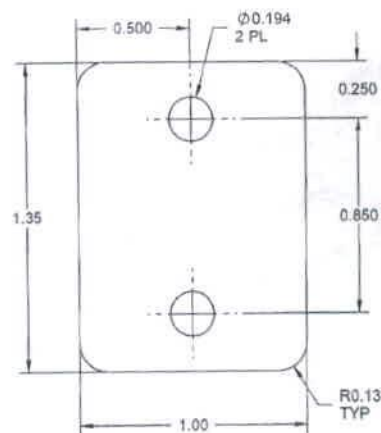




**D4015-1 WEARBAR**  
MAKE FROM D4015-1



#538/18



**D4015-1F WEARBAR FLAT PATTERN**

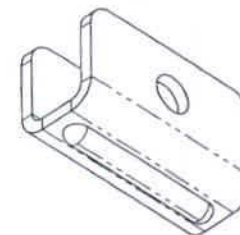
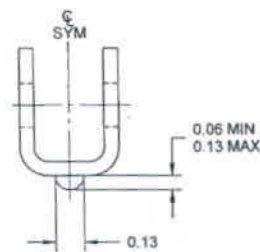
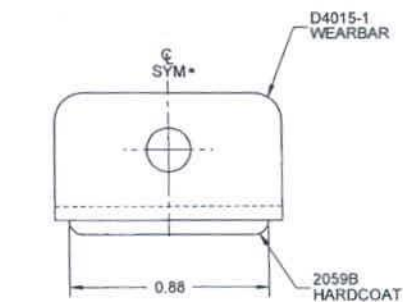
**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)  
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240  
REF. DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
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CHECKED	AS	DRAWING NO.	REV. B
MFG. APPR.	AS	D4015	SHEET 2 OF 2
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	WEARBAR WELDMENT	NTS
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ITEM	QTY	P/N	DESCRIPTION
1	1	D4015-041	WEARBAR WELDMENT
11	1	D4015-1	WEARBAR
21	A/R	2059B	HARDCOAT



**D4015-041 WEARBAR WELDMENT**

53818

**RELEASED**  
2009-11-24  
MD

**NOTES:**

- 1) MATERIAL: SEE SHEET 2 FOR D4015-1
- 2) FINISH: POWDER COAT "BLACK SANDEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs
- 8) WELDING: PER DART QSI 004

B	CHANGED COLOR TO BLACK SANDEX	MB	09.11.13
A	NEW ISSUE	MB	09.10.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED	AS		
MFG. APPR.	DS		
APPROVED			
DE APPR.			
DATE	09.11.13		

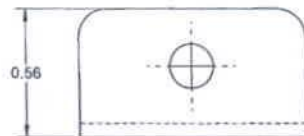
**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4015** REV. B  
TITLE **WEARBAR WELDMENT** SCALE NTS

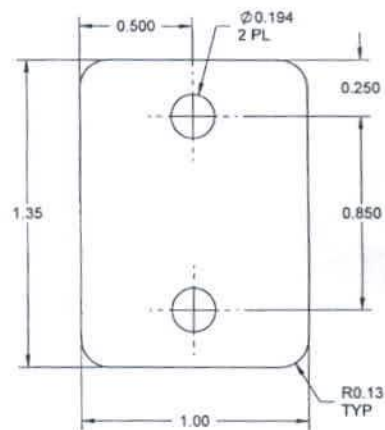
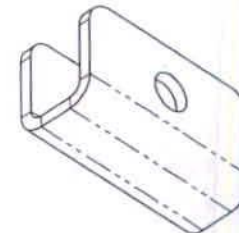
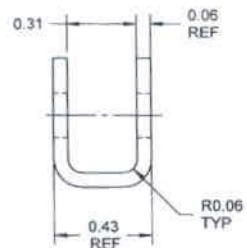
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**D4015-1 WEARBAR**  
MAKE FROM D4015-1



**D4015-1F WEARBAR FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)  
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240  
REF. DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

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CHECKED	<i>AS</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>DS</i>	D4015	SHEET 2 OF 2
APPROVED	<i>HO</i>	TITLE	SCALE
DE APPR.	<i>H</i>	<b>WEARBAR WELDMENT</b>	NTS
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53818

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2009-11-24

